

Rush

Work Order ID 122387

122387

Page 1

Item ID: D4977-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket, LH

Start Date: 7/15/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4977

C

110

0.00

110

Outsource5

Memo

0.00

Outsource process - Machining

ISSUE P/O: 25010
POSSIBLE SUPPLIER: WEJAY

Certificate of conformaty required

CL 14/07/15 5

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

5x-SP14-8-22

117

QC6- Inspect dimensions to drawing

0.00

117

QC

Memo

0.00

Quality Control

DAS
16
9-89

14/08/22

④

-1

Work Order ID 122387

122387

Page 2

July-15-14 12:40:02 PM

Item ID: D4977-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket, LH

Start Date: 7/15/14 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Outsource process-Anodize per QSI017 4.1.10.1

0.00

120

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O to ATG: 25511

1- Black Anodize as per Dwg

2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

QC 14

130

Receive & Inspect for Damage & Mat'l Certs

0.00

130

Packaging

Memo

0.00

Packaging

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

C2 14/08/25 5

14-08-27 (5)

DAS
41
9-89

14-8-28 (5)

14/8/27 (5)

DAS
38
9-89

5 14-8-27

Work Order ID 122387***122387***

Page 3

July-15-14 12:40:02 PM

Item ID: D4977-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket, LH
Start Date: 7/15/14 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/08/14 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 Identify as per dwg & Stock Location: 5129 0.00

180

Packaging Memo 0.00

Packaging ***IDENTIFY BY STAMPING P# AND REV***

MF 14-08-28

190 QC21- Final Inspection - Work Order Release 0.00

190

QC Memo 0.00

Quality Control

MLG 14-08-28MF 14-8-28

Picklist Print

July-15-14 12:40:01 PM

Page 1

Work Order ID: 122387

122387

Parent Item: D4977-1

D4977-1

Parent Item Name: Bracket, LH

Start Date: 7/15/14

Required Date: 8/08/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV: A NEW ISSUE JFS 13/11/22 VERIFY BY: JLM IPP
REV:B 14.06.16 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B4.000X03.00 0		Purchased	No				f	6.0600		2			

M7075T6B4 000X03 000

7075-T6 BAR 4.000' X 3.000"

**

N/A met sup by
Wejays

Location

Loc Qty

Loc Code

MAT001

6.06

125584

1

M127736

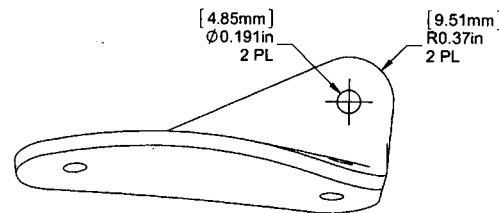
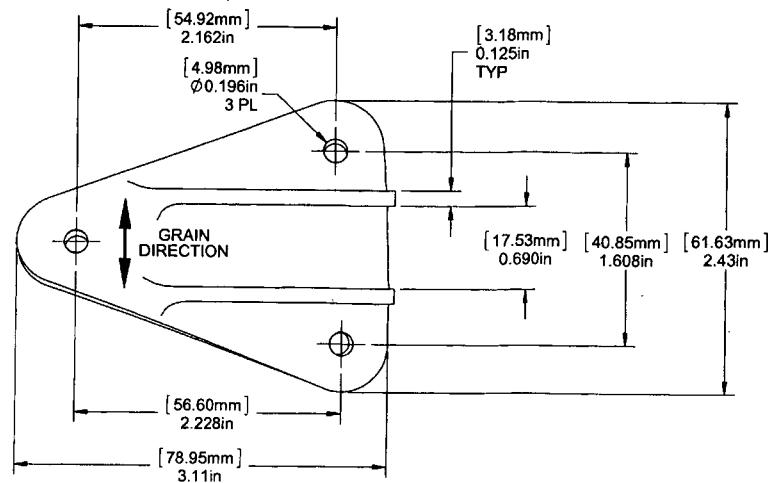
5.06

D4977-1P

X 5

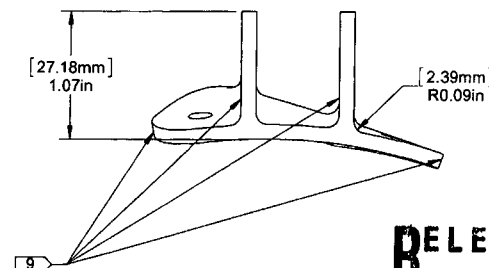
122387

ME 14-8-28



*WLO
122387*

D4977-1 BRACKET, LH



NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-1-c.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

C	REVISE NOTE 6) ZN (A8-1, A8-2)	AK	14.06.05
B	MODIFIED BRACKET GEOMETRY	AK	14.05.02
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4977 TITLE BRACKET	
DRAWN	RF		
CHECKED	HS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	BRACKET NTS	
DATE	14.06.05	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

APPROVED

RELEASED
2014-06-11



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25010**

Purchase Order Date 7/15/2014

PO Print Date 7/15/2014

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: FedEx PI ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
----------	---	------------------------	--------------------------------------	----	--------------------------------	---------------	---------------

1	D4970-3P	Windshield Deflector, Upper	8/22/2014 Yes 8/22/2014	FN	5.00 Each	\$950.00	\$4,750.00
---	----------	--------------------------------	-------------------------------	----	--------------	----------	------------

AS PER DWG D4970 REV. C
B122215

Line Total: \$4,750.00

2	D4977-1P	Bracket, LH	8/22/2014 Yes 8/22/2014	FN	5.00 Each	\$425.00	\$2,125.00
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AS PER DWG D4977 REV. C
B122387

Line Total: \$2,125.00

SP14-8-22

Note:

7/15/2014



Packing Slip 36927

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1
TEL: 613-384-1662 FAX: 613-384-21
www.wejay.c

S
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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA	
		PO25010		07/15/14		Best way	
CUSTOMER CODE			PROV. LIC. NO.		Extra		TERMS
EART					<input type="checkbox"/>		
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION				UNIT PRICE
5	-	5	Windshield deflector, upper as per drawing D4970, Rev. C D4970-3P B122215				
5	-	5	Bracket, left hand as per drawing D4977-1, Rev. C D4977-1P B122387				
5	-	5	Bracket, right hand as per drawing 4977-2, Rev. C D4977-2P B122388				
Required by: August 22, 2014							
<p align="center">RELEASE NOTE</p> <p>I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>Inspection Supervisor <i>[Signature]</i> WMP 03</p> <p align="center"><i>Aug. 21/14</i></p>							
							G.S.T.
							P.S.T.

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY

1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITH
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2901

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace Ltd.

DATE: Aug. 21, 2014

P.O.# PO25010

WEJAY JOB# 36927

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4970-3P 'Upper Windshield Deflector' B122215	5	Machined complete per drawing req'ts.	D4970 / rev. C
D4977-1P 'Bracket, Left Hand' B122387	5	Machined complete per drawing req'ts.	D4977 / rev. C
D4977-2P 'Bracket, Right Hand' B122388	5	Machined complete per drawing req'ts.	D4977 / rev. C

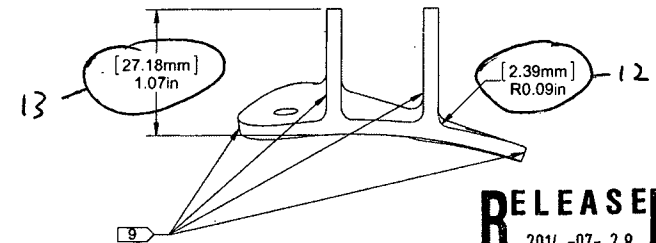
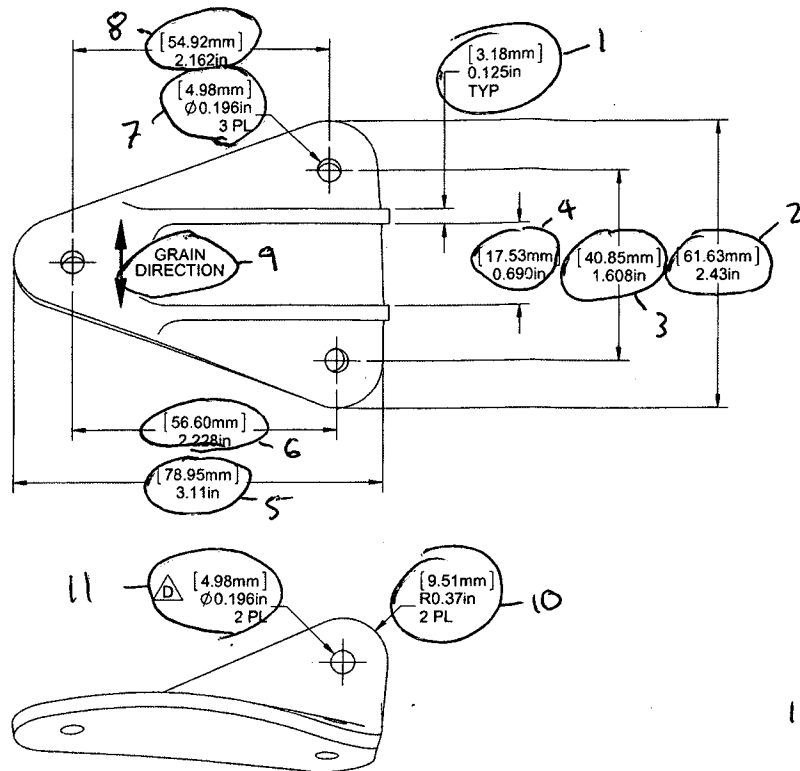
Note: 1) Material is Dart Aerospace free issue. Ref. Dart PO# PO22281.
2) 1st Article Inspection reports attached.

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith

Authorized Q.A. Signatory



D4977-1 BRACKET, LH

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4977-1", REVISION, BATCH NUMBER AND
DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.09 lbs (0.04 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4977-1.d.IGES
- 9) IT IS ACCEPTABLE FOR THESE EDGES TO BE PARALLEL WITH EACH OTHER

D	REVISED CLEVIS HOLE DIMENSIONS FROM Ø0.191 to Ø0.196 (ZN B5-1, ZN B5-2)	AK	14.07.14
C	REVISE NOTE 6) ZN (A8-1, A8-2)	AK	14.06.05
B	MODIFIED BRACKET GEOMETRY	AK	14.05.02
A	NEW ISSUE	DC	13.11.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4977	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No.

36927

PAGE: 1 of 1

CUSTOMER: DART Aerospace

CUST. P.O.# 25010

PART No. D4977-1

DESCRIPTION: BRACKET L.H.

DWG No. D4977

REV. D

E.C.O.

MATERIAL: 7075 ASTM B209 DART Supplied

INSPECTOR

IN PROCESS:

FINAL:

DATE:

QUANTITY

ACCEPT:

REJECT:

N.C.R.#

REC'D: 5

5

0

—

AUG 21/14

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	IN PROCESS INSPECTION	FINAL INSPECTION	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	0.125" TYP		$\pm .01$.125-.127		
2	2.43"		$\pm .03$			2.435		
3	1.608"		$\pm .01$			1.607		
4	.690"		$\pm .01$.690		
5	3.11"		$\pm .03$			3.10		
6	2.228"		$\pm .01$			2.230		
7	0.196" dia. 3pl.		$\pm .005 / -.001$.197		
8	2.162"		$\pm .01$			2.161		
9	Grain Direction				verified before machining			
10	R0.37" 2 places		$\pm .03$.37 R		1
11	0.196" dia x2		$\pm .005 / -.001$.197 ± 2		
12	R.09"		$\pm .03$.09 R.		
13	1.07"		$\pm .03$			1.070		
14								
15								
16								
17								
18								
19								
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21								
22								
23								
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34								



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63226

Date: 27-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To



DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
5 ea	Part: D4977-1 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140538 PO: PO25511		
5 ea	Part: D4977-2 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140539 PO: PO25511		
5 ea	Part: D4970-3 HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 Job: 20140540 PO: PO25511		
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : <u>27/8</u></p> <p>CERTIFIED SIGNATURE: </p> <p>RECEIVER SIGNATURE: </p>			